

# Work Order ID 120365

Wednesday, June 04, 2014 3:03:06 PM

**\*120365\***

Page 1

Item ID: D350-689-021 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Dual High Back Seat Installation - Energy Attenuating Seat Compatible  
 Start Date: 6/04/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 6/04/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 14-06-06 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr     | Revision Nbr |
|--------------|--------------|
| DSI 9588     | B            |
| IIN-D350-689 | B            |

|                               |   |      |           |  |  |  |  |  |                  |
|-------------------------------|---|------|-----------|--|--|--|--|--|------------------|
| 100                           | Document Control  | 0.00 | <u>SP</u> |  |  |  |  |  | DAS<br>9<br>9-89 |
| <b>*100*</b>                  | DOCUMENT CONTROL  |      |           |  |  |  |  |  |                  |
| DC                            | Memo  | 0.00 |           |  |  |  |  |  |                  |
| Doc.Control -USB or Paperwork | Photocopy bluefile and create labels per PPP D350-689-021 <del>SHG005</del> |      |           |  |  |  |  |  |                  |

|              |          |      |  |  |  |  |  |  |                   |
|--------------|----------|------|--|--|--|--|--|--|-------------------|
| 110          | Pick Kit | 0.00 |  |  |  |  |  |  | DAS<br>26<br>9-89 |
| <b>*110*</b> |          |      |  |  |  |  |  |  |                   |
| Packaging    | Memo     | 0.00 |  |  |  |  |  |  |                   |
| Packaging    |          |      |  |  |  |  |  |  |                   |

DEC 05 2014

DAS  
26  
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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|  |  |   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>   | Water Jet <input type="checkbox"/>  | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>   | Prod. Eng. Coord. <input type="checkbox"/>  | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>   | Rec/Store/Packaging <input type="checkbox"/>  | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>   | Supplier <input type="checkbox"/>   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |

| Root Cause                             | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design <input type="checkbox"/>        |      |      |     |   |                   |                    |             |              |              |
| Doc/Data <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling <input type="checkbox"/> |      |      |     |   |                   |                    |             |              |              |
| Handling/Pre <input type="checkbox"/>  |      |      |     |   |                   |                    |             |              |              |
| Material <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Operator <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Offset/Setup <input type="checkbox"/>  |      |      |     |   |                   |                    |             |              |              |
| Process <input type="checkbox"/>       |      |      |     |   |                   |                    |             |              |              |
| Supplier <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Training <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Transport <input type="checkbox"/>     |      |      |     |   |                   |                    |             |              |              |
| Unapproved <input type="checkbox"/>    |      |      |     |   |                   |                    |             |              |              |

### FAULT CATEGORY

|  |  |   |  |  |
|--|--|---|--|--|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crimp/Kink/Ripple/Wave<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Crushing<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Marks/Chatter<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damage/Defect<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program<br><input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete/Unqualified<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Misaligned/off center<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Off-set<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Set-up<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other |
|--|--|---|--|--|



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|  |  |   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>   | Water Jet <input type="checkbox"/>  | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>   | Prod. Eng. Coord. <input type="checkbox"/>  | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>   | Rec/Store/Packaging <input type="checkbox"/>  | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>   | Supplier <input type="checkbox"/>   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |

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| Equip/Tooling <input type="checkbox"/> |      |      |     |   |                   |                    |             |              |              |
| Handling/Pre <input type="checkbox"/>  |      |      |     |   |                   |                    |             |              |              |
| Material <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Operator <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Offset/Setup <input type="checkbox"/>  |      |      |     |   |                   |                    |             |              |              |
| Process <input type="checkbox"/>       |      |      |     |   |                   |                    |             |              |              |
| Supplier <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Training <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Transport <input type="checkbox"/>     |      |      |     |   |                   |                    |             |              |              |
| Unapproved <input type="checkbox"/>    |      |      |     |   |                   |                    |             |              |              |

### FAULT CATEGORY

|  |  |   |
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| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crimp/Kink/Ripple/Wave<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Crushing<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Marks/Chatter<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damage/Defect<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program<br><input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete/Unqualified<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Misaligned/off center<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Off-set<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence |
| <input type="checkbox"/> Outside Dimensions<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge   |  |   |
| <input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Set-up<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other   |  |   |

# Picklist Print

Wednesday, June 04, 2014 3:03:06 PM

Page 1

Work Order ID: 120365

**\*120365\***

Parent Item: D350-689-021

**\*D350-689-021\***

Parent Item Name: Dual High Back Seat Installation - Energy Attenuating Seat Compatible

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-12-23 new issue DD verified by: LL 08.12.24 IPP  
Rev:B chg002 DD 10.02.12 verified by:JLM IPP Rev:C  
chg004 DD 11.09.28 verified by:JLM IPP Rev:D 12.01.12  
now @ CHG005 (ecn12-501) DD VERF:EC

| Component Item ID/<br>Item Name                       | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status            |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|-------------------|
| D350-689-023  |                        | Manufactured  | No          |                     |                  | 110             | Each               | 0.0000         | 1           | 1            |               |                | DAS<br>06<br>9-89 |
| <b>*D350-689-023*</b>                                 |                        |               |             |                     |                  |                 |                    |                | **          | 120462       |               |                | DAS<br>26<br>9-89 |
| Floor Provisions - Energy Attenuating Seat Compatible |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |                   |
| D350-689-043  |                        | Manufactured  | No          |                     |                  | 110             | Each               | 0.0000         | 1           | 1            |               |                | DAS<br>06<br>9-89 |
| <b>*D350-689-043*</b>                                 |                        |               |             |                     |                  |                 |                    |                | **          | 126949       |               |                | DAS<br>26<br>9-89 |
| Dual High Back Seat Ass"Y                             |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |                   |
| D3018-1   |                        | Manufactured  | No          |                     |                  | 110             | Each               | 6.0000         | 1           | 1            |               |                | DAS<br>06<br>9-89 |
| <b>*D3018-1*</b>                                      |                        |               |             |                     |                  |                 |                    |                | **          | 120768       |               |                | DAS<br>26<br>9-89 |
| Seat Cushion  |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |                   |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  | <u>Loc Code</u>    |                |             |              |               |                |                   |
|   |                        |               |             | st196a              |                  | 4               |                    |                |             |              |               |                |                   |
|   |                        |               |             | 116961              |                  | 4               |                    |                |             |              |               |                |                   |
|   |                        |               |             | ST264A              |                  | 2               |                    |                |             |              |               |                |                   |
|   |                        |               |             | 106774              |                  | 1               |                    |                |             |              |               |                |                   |
|   |                        |               |             | 110970              |                  | 1               |                    |                |             |              |               |                |                   |
| D3019-1   |                        | Manufactured  | No          |                     |                  | 110             | Each               | 5.0000         | 1           | 1            |               |                | DAS<br>06<br>9-89 |
| <b>*D3019-1*</b>                                      |                        |               |             |                     |                  |                 |                    |                | **          | 120370       |               |                | DAS<br>26<br>9-89 |
| Back Cushion  |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |                   |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  | <u>Loc Code</u>    |                |             |              |               |                |                   |
|   |                        |               |             | ST202A              |                  | 4               |                    |                |             |              |               |                |                   |
|   |                        |               |             | 117042              |                  | 4               |                    |                |             |              |               |                |                   |
|   |                        |               |             | ST264A              |                  | 1               |                    |                |             |              |               |                |                   |
|   |                        |               |             | 110998              |                  | 1               |                    |                |             |              |               |                |                   |

DAS  
06  
9-89  
DEC 05 2014

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|  |  |   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>   | Water Jet <input type="checkbox"/>  | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>   | Prod. Eng. Coord. <input type="checkbox"/>  | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>   | Rec/Store/Packaging <input type="checkbox"/>  | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>   | Supplier <input type="checkbox"/>   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |

| Root Cause                             | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design <input type="checkbox"/>        |      |      |     |   |                   |                    |             |              |              |
| Doc/Data <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling <input type="checkbox"/> |      |      |     |   |                   |                    |             |              |              |
| Handling/Pre <input type="checkbox"/>  |      |      |     |   |                   |                    |             |              |              |
| Material <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Operator <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
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| Training <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Transport <input type="checkbox"/>     |      |      |     |   |                   |                    |             |              |              |
| Unapproved <input type="checkbox"/>    |      |      |     |   |                   |                    |             |              |              |

### FAULT CATEGORY

|  |  |   |
|--|--|---|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crimp/Kink/Ripple/Wave<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Crushing<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Marks/Chatter<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damage/Defect<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program<br><input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete/Unqualified<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Misaligned/off center<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Off-set<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence |
|  |  | <input type="checkbox"/> Outside Dimensions<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge  |
|  |  | <input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Set-up<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other  |

# DART SERVICE INSTRUCTION

## TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. B AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 REV. 1

REF. TCCA STC: SH02-33  
REF. FAA STC: SR01620NY  
REF. EASA STC: EASA.IM.R.S.01453  
REF. TCA STC: 2005S03-09

### 1.0 PURPOSE

For D350-689-011/-013 at CHG 006/005 and later and D350-689-021/-023 Kits at CHG 005/004 and later, the D3026-1 Channel has been replaced with the D4575-1 Beam and D4575-3 Doubler and the D3234-3 Doubler has been removed. Consequently, the installation instructions for D350-689-011/-013 at CHG 006/005 and D350-689-021/-023 at CHG 005/004 are updated per Section 2.0 of this Service Instruction. The parts list update is shown in Section 4.0 of this Service Instruction. There is a negligible change to the weight and balance.

### 2.0 INSTALLATION CHANGES FOR D350-689-013

Section 3.9, *INSTALLATION OF D350-689-013 FLOOR PROVISIONS KIT* (pages 4 and 5 of IIN-D350-689), is changed as follows:

#### Item 3.3.15 is:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer as shown in Figure 1 of this Service Instruction. Transfer drill existing holes from the aircraft floor to the D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer as shown in Figure 1 of this Service Instruction and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

**Note:** Drill a Ø1.00" (Ø25.4 mm) hole in the D4575-1 Beam to clear extension tube of collective and cutout as required for clearance of collective opening and fwd bulkhead as shown in Figure 3 of this Service Instruction.

#### Item 3.3.15 was:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D3026-1 Channel as shown in Figure 4 and transfer existing holes from the aircraft floor to the D3026-1 Channel & D3032-1 Spacer. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D3026-1 Channel & D3032-1 Spacer as shown in Figure 4 and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

#### Item 3.3.17 is:

Counter sink holes in the D3032-1 Spacer for MS20426AD4 rivets. Install D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer to floor using MS20426AD4 rivets.

#### Item 3.3.17 was:

Counter sink holes in the D3032-1 Spacer for MS20426AD4 rivets. Install D3026-1 Channel and D3032-1 Spacer using MS20426AD4 rivets.

#### Item 3.3.22 is:

Rivet D3234-1 Doubler to D3025-1 Beam as shown in Figure 7 using MS20470AD4 rivets. Continue at step 3.3.25.

#### Item 3.3.22 was:

Rivet D3234-1 Doubler to D3025-1 Beam and D3234-3 Doubler to D3026-1 Channel as shown in Figure 7 using MS20470AD4 rivets. Continue at step 3.2.25.

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DAO # 01-O-01

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BY:

D. SHEPHERD (DE # 02)

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CERT. NO.: SH02-33  
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| B          | CHANGES TO -013 KIT INSTALLATION. REF: CIR12-12. | MB   | 12.11.09     |
| A          | NEW ISSUE  | MB   | 11.12.22     |
| REV.       | DESCRIPTION                                      | BY   | DATE         |
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### 3.0 INSTALLATION CHANGES FOR D350-689-023

Section 3.9, *INSTALLATION OF D350-689-023 ENERGY ATTENUATING FLOOR PROVISIONS KIT* (pages 8 and 9 of IIN-D350-689), is changed as follows:

**Item 3.9.8 is:**

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D4575-1 Beam and D4575-3 Doubler as shown in Figure 2 of this Service Instruction. Transfer drill existing holes from the aircraft floor to the D4575-1 Beam and D4575-3 Doubler. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D4575-1 Beam and D4575-3 Doubler as shown in Figure 1 of this Service Instruction and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

**Note:** Drill a Ø1.00" (Ø25.4 mm) hole in the D4575-1 Beam to clear extension tube of collective and cutout as required for clearance of collective opening and fwd bulkhead as shown in Figure 3 of this Service Instruction.

**Item 3.9.8 was:**

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D3026-1 Channel as shown in Figure 4 and transfer existing holes from the aircraft floor to the D3026-1 Channel. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D3026-1 Channel as shown in Figure 4 and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

**Item 3.9.10 is:**

Attach D4575-1 Beam and D4575-3 Doubler to floor using qty (14) MS20426AD4 rivets.

**Item 3.9.10 was:**

Attach D4575-1 Channel to floor using qty (14) MS20426AD4 rivets.

**Item 3.9.12 is no longer applicable:**

~~Rivet D3234-3 Doubler to D3026-1 Channel as shown in Figure 7 using MS20470AD4 rivets.~~

**Item 3.9.12 was:**

Rivet D3234-3 Doubler to D3026-1 Channel as shown in Figure 7 using MS20470AD4 rivets.

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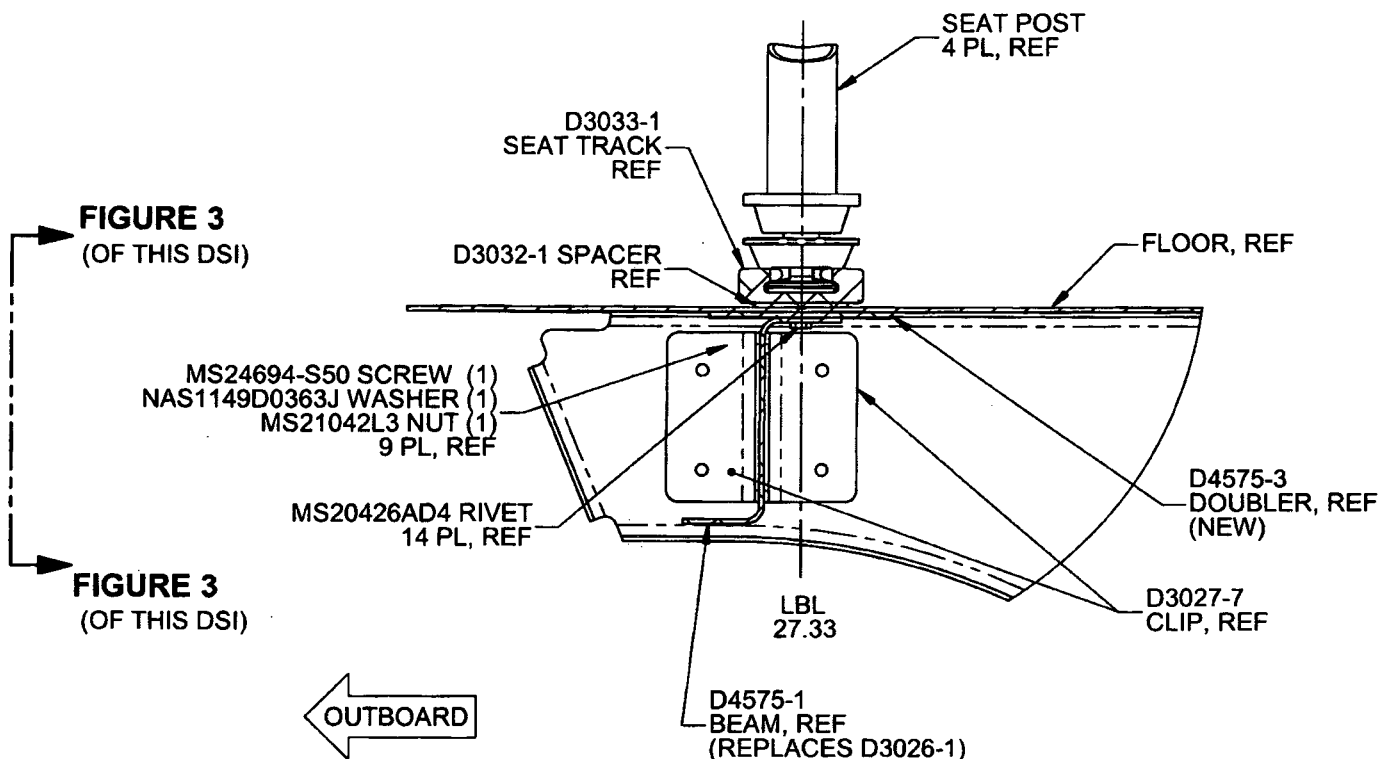
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**CROSS SECTION VIEW F-F/M-M: From Figures 5 and 7 (IIN-D350-689)**  
**CROSS SECTION VIEW F-F/M-M: From Figures 25-5 and 25-7 (ICA-D350-689)**

**FIGURE 1: UPDATES TO CROSS SECTIONS F-F AND M-M**

With reference to Figures 5 and 7 of IIN-D350-689  
 (Figures 25-5 and 25-7 of ICA-D350-689)

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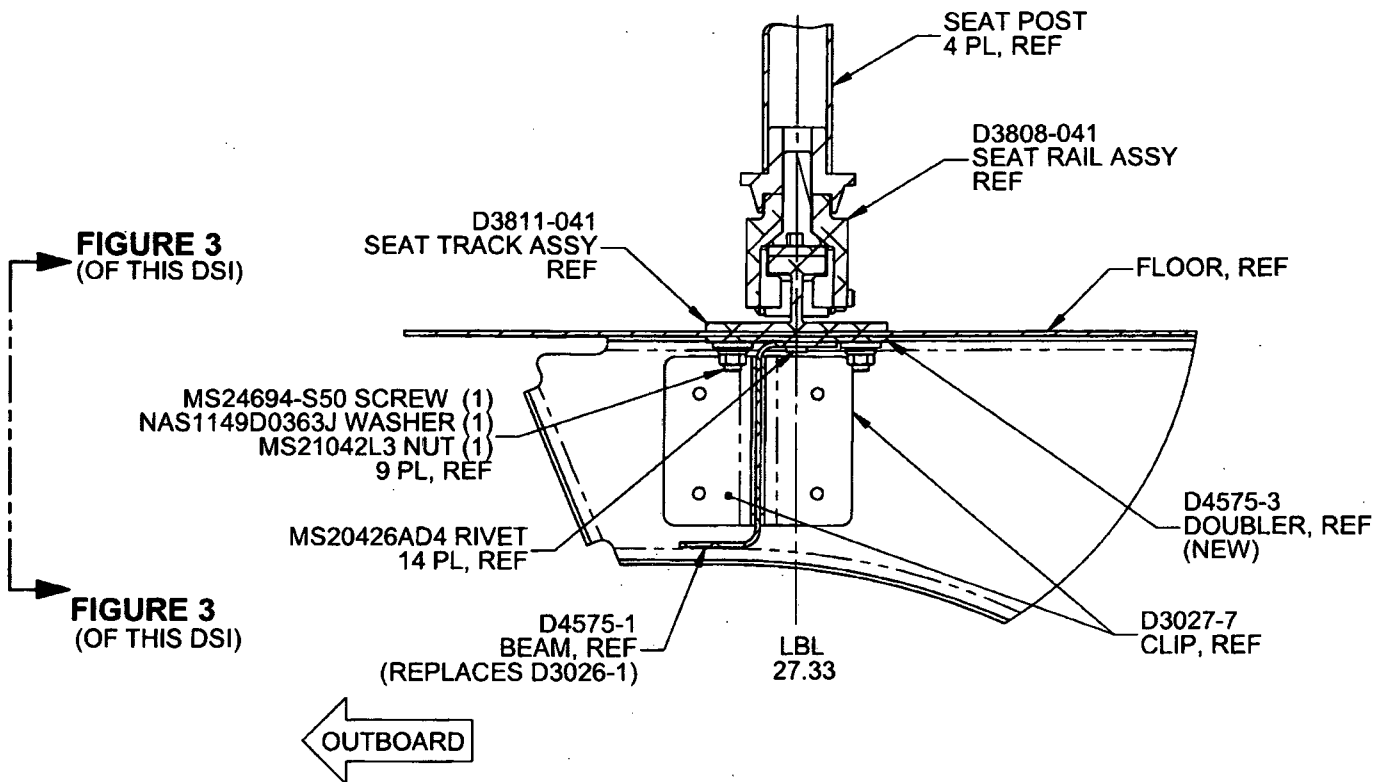
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**FIGURE 21: Cross Section View T-T from Figure 19 (IIN-D350-689)**  
**FIGURE 25-21: Cross Section View T-T from Figure 25-19 (ICA-D350-689)**

**FIGURE 2: UPDATES TO FIGURE 21 (IIN-D350-689) AND 25-21 (ICA-D350-689)**  
 With reference to Figures 19 and 20 of IIN-D350-689  
 (Figures 25-19 and 25-20 of ICA-D350-689)

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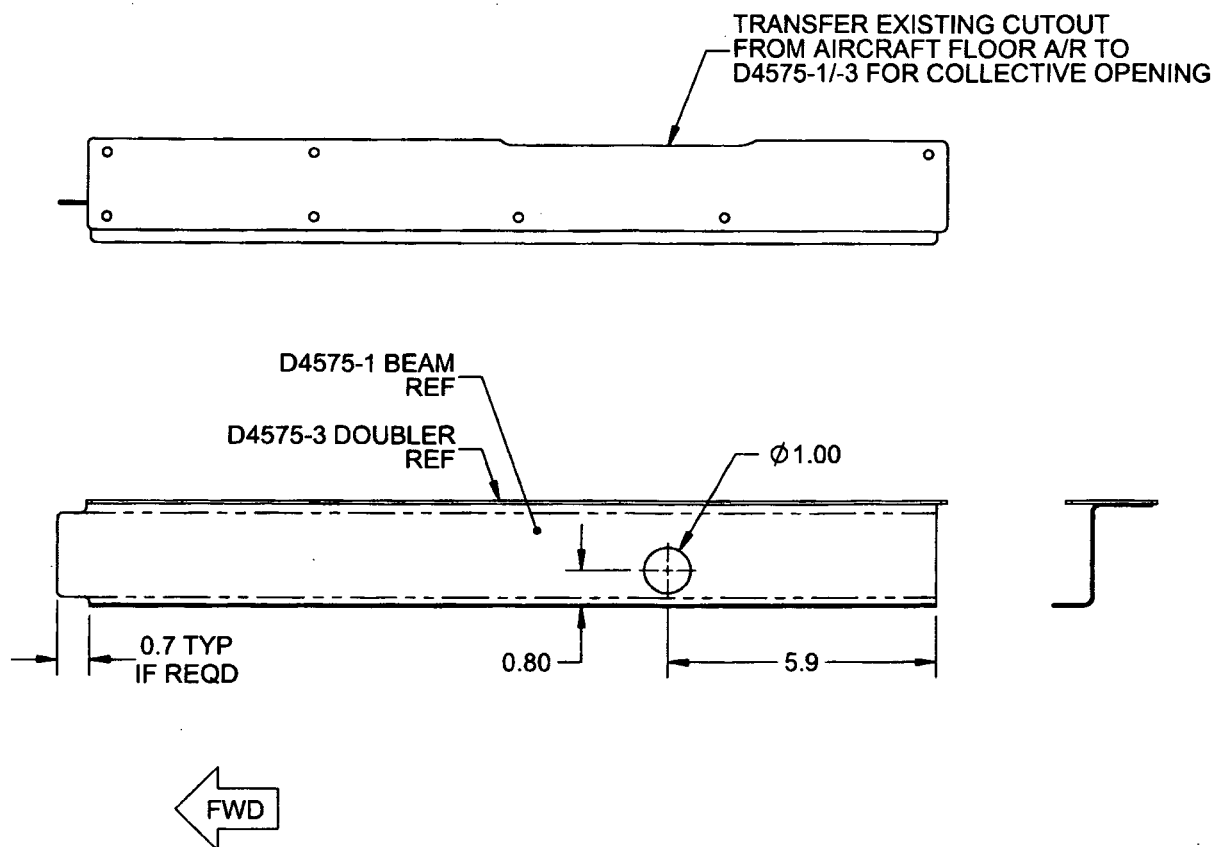
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**FIGURE 3: RELIEFS ON D4575-1/-3**  
(ONLY D4575-1/-3 SHOWN FOR CLARITY)  
VIEW LOOKING INBOARD

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#### 4.0 PARTS LIST CHANGE

The parts list of D350-689-021/-023 at CHG 005/004 or later is amended as follows:

#### 5. PARTS LIST (IIN-D350-689)

#### 25.10 PARTS LIST (ICA-D350-689)

IS:

| Qty<br>-011 | Qty<br>-013 | Qty<br>-015 | Qty<br>-017 | Qty<br>-019 | Qty<br>-021 | Qty<br>-023 | Qty<br>-041 | Qty<br>-043 | Part Number  | Description                                |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|--------------|--|
| X           |             |             |             |             |             |             |             |             | D350-689-011 | DUAL HIGH BACK SEAT<br>INSTALLATION, LH    |
| 1           | X           |             |             |             |             |             |             |             | D350-689-013 | FLOOR PROVISIONS KIT                       |
|             |             | X           |             |             |             |             |             |             | D350-689-015 | SEAT MODIFICATION KIT                      |
|             |             |             | X           |             |             |             |             |             | D350-689-017 | SHOULDER HARNESS KIT                       |
|             |             |             |             | X           |             |             |             |             | D350-689-019 | CONTROL GUARD KIT                          |
|             |             |             |             |             | X           |             |             |             | D350-689-021 | DUAL HIGH BACK SEAT<br>INSTALLATION, LH    |
|             |             |             |             |             | 1           | X           |             |             | D350-689-023 | ENERGY ATTENUATING FLOOR<br>PROVISIONS KIT |
| 1           |             |             |             |             |             |             | X           |             | D350-689-041 | DUAL HIGH BACK SEAT ASSEMBLY               |
|             |             |             |             |             | 1           |             |             | X           | D350-689-043 | DUAL HIGH BACK SEAT ASSEMBLY               |
|             |             |             |             |             |             |             |             |             | D3026-1      | CHANNEL (REMOVED)                          |
|             |             |             |             |             |             |             |             |             | D3234-3      | DOUBLER (REMOVED)                          |
|             | 1           |             |             |             |             | 1           |             |             | D4575-1      | BEAM (REPLACES D3026-1)                    |
|             | 1           |             |             |             |             | 1           |             |             | D4575-3      | DOUBLER (NEW)                              |

WAS:

| Qty<br>-011 | Qty<br>-013 | Qty<br>-015 | Qty<br>-017 | Qty<br>-019 | Qty<br>-021 | Qty<br>-023 | Qty<br>-041 | Qty<br>-043 | Part Number  | Description                                |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|--------------|--|
| X           |             |             |             |             |             |             |             |             | D350-689-011 | DUAL HIGH BACK SEAT<br>INSTALLATION, LH    |
| 1           | X           |             |             |             |             |             |             |             | D350-689-013 | FLOOR PROVISIONS KIT                       |
|             |             | X           |             |             |             |             |             |             | D350-689-015 | SEAT MODIFICATION KIT                      |
|             |             |             | X           |             |             |             |             |             | D350-689-017 | SHOULDER HARNESS KIT                       |
|             |             |             |             | X           |             |             |             |             | D350-689-019 | CONTROL GUARD KIT                          |
|             |             |             |             |             | X           |             |             |             | D350-689-021 | DUAL HIGH BACK SEAT<br>INSTALLATION, LH    |
|             |             |             |             |             | 1           | X           |             |             | D350-689-023 | ENERGY ATTENUATING FLOOR<br>PROVISIONS KIT |
| 1           |             |             |             |             |             |             | X           |             | D350-689-041 | DUAL HIGH BACK SEAT ASSEMBLY               |
|             |             |             |             |             | 1           |             |             | X           | D350-689-043 | DUAL HIGH BACK SEAT ASSEMBLY               |
|             | 1           |             |             |             |             | 1           |             |             | D3026-1      | CHANNEL                                    |
|             | 1           |             |             |             |             | 1           |             |             | D3234-3      | DOUBLER                                    |

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**Work Order ID 120365**

Wednesday, June 04, 2014 3:03:06 PM

**\*120365\***

Page 1

Item ID: D350-689-021

Accept

Revision ID:

**\*N900040100\***Setup Start **\*NS1\***

Item Name: Dual High Back Seat Installation - Energy Attenuating Seat Compatible

Stop **\*NS2\***Start Date: 6/04/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: MCS Date: 14-06-06 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

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| IIN-D350-689 | B            |

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